

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014671**Date Inspected:** 20-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed no apparent welding work in progress in Bay 10:

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

Heat straightening being performed on part number ESD1-SPSA5-7 in conformance with HSR1(T)-11265, dated 4/18/10, and presented to this QA Inspector by ZPMC QC Xu Jie, who was not a CWI. ZPMC QC Xu Jie informed this QA Inspector that the CWI assigned to this work was ZPMC CWI An Qing Xiang (QC1).

Heat straightening being performed on part number ESD1-SPSA5-16 in conformance with HSR1(T)-11266, dated 4/18/10, and presented to this QA Inspector by ZPMC QC Xu Jie, who was not a CWI. ZPMC QC Xu Jie informed this QA Inspector that the CWI assigned to this work was ZPMC CWI An Qing Xiang (QC1).

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of an indication observed by visual testing by ZPMC personnel located on pike path

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assembly PCMK BK1-030. Welder was identified as 053753. QC was identified as ZPMC CWI Li Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Feng Ya Jun, who was not a CWI. Neither QC1 nor ZPMC QC Feng Ya Jun were able to provide a specific weld number for this location. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2211-TC-U4b-FCM-1. Also present at this location and observing the welding operation was ABF Representative ZhangXiao Bin.

Heavy Dock

This QA Inspector randomly observed no apparent welding related work in progress on the Heavy Dock. ABF Representative Zhao Ying Sheng informed this QA Inspector that ZPMC workers were performing fit-up of the vertical base plate between west tower lift 1 and south tower lift 1 and no welding was being performed. The ZPMC 4000 ton floating crane was moored to the foot of the heavy dock and with lifting gear positioned over the lifts 1/2 tower trial assembly.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
